

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-028070**Date Inspected:** 27-Jul-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** See below.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Quality Assurance Inspector (QA) Fritz Belford was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

OBG

This QA Inspector observed AB/FJV personnel grinding on weld 12W W2.1-C1 flush on the exterior side at Y location 17500. Nearby this QA Inspector observed QC Inspector Scott Krotum initiating the Ultrasonic Testing (UT) on the exterior side of weld 12W PP111.1-C.

Internally of OBG 12W it was noted that Jimmy Zhen (Welder ID #6001) had progressed to Y 28000 on weld 12W W2.1-A1, and Welder Jin Pei Wang (Welder ID #7299) was noted on the same weld at location Y 21000 welding. Both welders were utilizing Caltrans approved Welding Procedure Specification's (WPS) ABF-WPS-D15-3110-4 for Flux Core Arc Welding.

Authorized welder Mike Jimenez (Welder ID #4671) was noted welding on the CJP splice welds for weld 12W PP111.1-LS3, utilizing Caltrans approved Welding Procedure Specification's (WPS) ABF-WPS-D15-1012-3.

Magnetic Particle Testing

This QA performed Magnetic Particle Testing (MT) on the following welds:

- 13W PP123 W2.8 BF2
- 13W PP124.5 W2.8-BW1

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The above welds were previously accepted by QC Magnetic Particle technicians. This QA observed no rejectable indications at the time of testing. This QA Inspector generated a TL-6028 MT report on this date. The completed work observed at this location appeared to be in compliance with the contract specifications.

Ultrasonic Testing

This QA performed Ultrasonic Testing (UT) on the following welds:

- 13W PP123 W2.8 BF2
 - o No rejectable indication noted.
- 13W PP124.5 W2.8-BW1
 - o One (1) rejectable indication and one (1) recordable indication noted.

Both welds were previously accepted by QC Ultrasonic technicians in accordance with AWS D1.5-2002, section 6, table 6.3. This QA observed one reject in weld 13W PP124.5 W2.8-BW1 and has notified QC Bonifacio Daquinag Jr. of the rejected weld and indication parameters. This QA was informed by QC Bonifacio Daquinag Jr. the rejected weld will be re inspected on the following day. This QA completed a TL-6027 UT for the welds inspected on this date.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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Summary of Conversations:

Conversations relevant to work performed on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy - (510) 385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Belford,Fritz	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
